

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020698**Date Inspected:** 16-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 1

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07806 from ZPMC for Bay 1. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as Steel Barriers. The weld designations reviewed are as follows.

E2-SB1-049-126~129

E2-SB1D-045-126~129, 064~067

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.

ZPMC QC is identified as Zhu Jun

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector

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Component: Grillage
PCMK: SA7512
Weld Number: 030
Welder: 066002
WPS-345-SMAW-3G-FCM-Repair
B-CWR2349

Component: Grillage
PCMK: SA7512
Weld Number: 032
Welder: 066002
WPS-345-SMAW-3G-FCM-Repair
B-CWR2353

Component: Grillage
PCMK: SA7512
Weld Number: 037
Welder: 045221
WPS-345-SMAW-3G-FCM-Repair
B-CWR2351

Component: Grillage
PCMK: SA7512
Weld Number: 060
Welder: 045246
WPS-345-SMAW-3G-FCM-Repair
B-CWR2308

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shielded Metal Arc Welding (SMAW) processes.
ZPMC QC is identified as Xu Hihyang
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector

Component: Cross Beam
PCMK: CB3003A-019
Weld Number: 005
Welder: 048659, 054467
WPS-345-SMAW-2G-FCM-Repair
B-CWR2472

Component: Cross Beam

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PCMK: CB3003A-019
Weld Number: 017
Welder: 049769
WPS-345-SMAW-4G-FCM-Repair
B-WR18720

Bay 8

This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Flux Core Arc Welding (FCAW) processes.
ZPMC QC is identified as Feng Ya Jun
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector

Component: Bike Path
PCMK: BK004A6-057
Weld Number: 086
Welder: 500405
WPS-B-T-2333-ESAB

Component: Bike Path
PCMK: BK004A6-057
Weld Number: 088
Welder: 054459
WPS-B-T-2333-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
